



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

→ **D5506-3**
Job Sheet 196676



Part No: D5506-3

Job Qty: 2 pcs

Part Name: Base, Lower Cutter, Long



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/18/19

Job Tracking No:

Due Date: 7/16/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: D5506 REV.A10 IPP REV:A 17.11.13 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Purchasing	2 pcs	7/16/19		0.00	0.00	Purchasing - 1	JUL 11 2019	
							Purchasing - 2		
							Purchasing - 3		
130	Packaging 2-1 - Receive - B4B	2 pcs	7/16/19		0.00	0.00	Packaging 2 - 1 - B4B	JUL 11 2019	
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		

ART

ROSPACE

No: S197504



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
Tel.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S197504



Part: D5506-3

Job No: 196676

Serial No/Batch: S197504

Revision: A10

Inspector:

Exp Date:

Instructions:

Date: 07/11/19

Plex 6/18/19 3:57 PM dart.lussier.patrick

P.T.O.

				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
140 QC 6	2 pcs	7/16/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	DAS 40
				QC 6 - 40	JUL 17 2019 9-89
142 Outsource - 4 - Anodize	2 pcs	7/16/19		ATG001-VC	MA 2019-07-15
144 Packaging 2-2 - Receive - B4B	2 pcs	7/16/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP JUL 19 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
146 QC 6	2 pcs	7/16/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	DAS 61
				QC 6 - 40	9-89
150 Packaging 3-1 - Stock - B4B	2 pcs	7/16/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	OR 89: cct 1234
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	2 pcs	7/16/19	0.00 0.00	QC 21 - SA - 21 →	Bn: CCK1234
				QC 21 - SA - 70	
				QC 21 - SA - 53	JUL 26 2019
Part Op 120 - Purchasing - Issue P/O to Wejay: <u>HB043778</u> Manufacture as per dwg Certification of Conformity is required Descriptions: 130 - Receive & Inspect for Damage & Mat'l Certs 142 - Issue P/O to ATG: <u>44008</u> HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** Certification of Conformity is required 150 - Identify as per dwg & Stock Location: _____ 160 - QC21- Final Inspection - Work Order Release x 2 plus June 18. 2019					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D5506-3P	Base, Lower Cutter, Long	2 Ea (1 ea)	120-Purchasing	5197503	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
120-Purchasing	D5506-3P	2	0	0	
Part Specifications					
Specifications could not be found.					

DAS
70
9-89

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043778



Supplier: WEJ001-VC
Wejay Machine Products Co. Ltd
800 O'Connor Drive
Kingston
ON
K7P 1N3 Canada
Phone: 613-384-1662
Fax: 613-384-2997

PO No: POHB043778
PO Date: 6/18/19
Due Date: 7/16/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196673	D5500-1P			Body, Upper Cutter As per Dwg D5500 Rev. A	Firmed	-	7/16/19	3 Ea	0 Ea	3 Ea	\$2,436.00/Ea	\$7,308.00
2	196674	D5501-1P			Body, Lower Cutter, Long As per Dwg D5501 Rev. A	Firmed	-	7/16/19	2 Ea	0 Ea	2 Ea	\$3,144.00/Ea	\$6,288.00
3	196675	D5505-1P			Base, Upper Cutter : Various STC's As Per Dwg D5505-1 Rev. A	Firmed	-	7/16/19	3 Ea	0 Ea	3 Ea	\$1,120.00/Ea	\$3,360.00
4	196676	D5506-3P			Base, Lower Cutter, Long As Per Dwg 5506 Rev. A	Firmed	-	7/16/19	2 Ea	0 Ea	2 Ea	\$1,447.00/Ea	\$2,894.00

Grand Total: \$19,850.00

EAS
40
9.89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB043778



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

A handwritten signature in black ink, appearing to be "Plex" or similar, located to the right of the procurement quality clauses list.

Plex 6/18/19 3:57 PM dart.lussler.patrick



Packing Slip 39579

600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3
 TEL: 613-384-1662 FAX: 613-384-2997
 www.wejay.com

SOLD TO
 Dart Aerospace
 1270 Aberdeen Street
 Hawkesbury ON K6A 1K7

SHIP TO
 Dart Aerospace
 1270 Aberdeen Street
 Hawkesbury ON K6A 1K

INVOICE DATE		YOUR ORDER NO. PCRE043778		DATE ORDERED 06/18/19		SHIPPED VIA Best way	
CUSTOMER CODE PART		PROV. LIC. NO.		Extra ☐ Exempt ☐		TERMS	
QUANTITY ORDERED	B.O.	QUANTITY SHIPPED	DESCRIPTION			UNIT PRICE	AMOUNT
3	0	3	Body, upper cutter as per drawing D5500, Rev. A Part No. D5500-1P				
2	0	2	Body, lower cutter, long as per drawing D5501, Rev. A Part No. D5501-1P				
3	0	3	Base, upper cutter, various STC as per drawing D5505-1, Rev. A Part No. D5505-1P				
2	0	2	Base, lower cutter as per drawing D5506-3, Rev. A Part No. D5506-1P -3P				

RECEIVED
 JUL 11 2019
 DART AEROSPACE LTD.

Required by: July 16, 2019

RELEASE NOTE

I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order.

Inspection Supervisor: *[Signature]* **WMP 03**
 July 10/19

H.S.T.

ORDER: COMPLETE ☐ PARTIAL ☐

TOTAL

RECEIVED BY: _____
 .5% PER MONTH (18% PER ANNUM)
 CHARGED ON OVERDUE ACCOUNTS

NO GOODS RETURNED WITHOUT
 PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: DART Aerospace

DATE: July 9, 2019

P.O.# POHB043778 item 4

WEJAY JOB# 39579

I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below.

PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D5506-3P 'Base, Lower Cutter' Job #196676	2	Machined complete per drawing req'ts.	D5506-3 / rev. A
Note: 1) Material: . Material Test Cert. attached - ref. 'Constellium' Lot# 9439433 (Wejay TN# 35073-3) 2) 1st Article Inspection / Test Report attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Sincerely,

DAS
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9-89

Clifford Smith

Authorized Q.A. Signatory

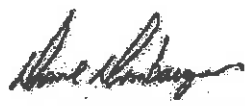


Constellium Rolled Products
Ravenswood, LLC

3

SHIP TO
THYSSENKRUPP CA
2821 LANGSTAFF ROAD
CONCORD ON
L4K 5C6
CA

SOLD TO
COPPER & BRASS SALES
PO BOX 5116
SOUTHFIELD MI
48066
US

COPPER&BR		110731616		4075		INCLUSION		Serial:20190205-0110731616		Pg 1of2	
CUSTOMER PURCHASE ORDER NO. & ITEM 5400424185-R01						Constellium ORDER NO. 264648					
ALLOY 7075	CLAD	TEMPER T651	GUAGE 2.53000 in 64.26 mm	WIDTH 60.50000 in 1,537 mm	LENGTH 144.50000 in 3,670 mm	CERTIFICATION "Constellium Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Constellium Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination." Constellium Rolled Products Ravenswood, LLC 859 Century Road P.O. BOX 68 RAVENSWOOD, WV 26164 USA  Dave Dunbar - Laboratory Manager					
ITEM ORDERED SPEC PLATE, SAWED MILL FINISH											
CUSTOMER SPECIFICATION AMS QQ-A-250/12A											
PART NUMBER ALFLR01004		B/L NUMBER 112706		DATE SHIPPED 02/05/2019							
WT. SHIPPED 7020.000 LB		NO. OF PIECES 000003		GOVT. CONTRACT NO.							
ALL LOTS ON THIS CERTIFICATION ALSO CONFORM TO THE FOLLOWING REQUIREMENTS:											
AMS 4045L ASTM B209-14 Load Details											
Package	Net Lbs	Kg	Lot	Piece	Serial	Parent Lot					
1001976384	2,340.000	1,061.405	9439433	01							
1001976384	2,340.000	1,061.405	9439433	02							
1001976385	2,340.000	1,061.405	9439433	03							
Lot: 9439433 (See test results below)											
Tensile - Room Temperature (US)											
		Ultimate (KSI)		Yield (KSI)		Elongation (%)		Report			
Direction	Tests	Min	Max	Min	Max	Min	Max				
LT	02	80.8	81.5	69.7	71.0	12.5	13.0				
Tensile - Room Temperature (SI)											
		Ultimate (N/MM2)		Yield (N/MM2)		Elongation (%)		Report			
Direction	Tests	Min	Max	Min	Max	Min	Max				
LT	02	557	562	481	490	12.5	13.0				
REF. DART P.O.#POHBO43778 ITEM 4 BASE, LOWER CUTTER - PART#D5506-3P											
TN35073-3 Job # 39579 rec'd June 24/19											
WMP 03 June 27/19											
P-860-155D REVISED: 01 2018											

From: TK Materials CA, Ltd.

Cust. WEJAY MACHINE PRODUCTS CO LTD Del.: 2406829910

CstAr CstOr 35073

Wgt.: 36.196 LB Date 06/20/2019





Constellium

Naacap
Materials Testing Laboratory

**Constellium Rolled Products
Ravenswood, LLC**

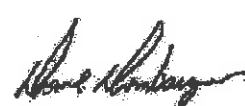
S
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THYSSENKRUPP CA
2821 LANGSTAFF ROAD
CONCORD ON
L4K 5C6
CA

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O

COPPER & BRASS SALES

PO BOX 5118
SOUTHFIELD MI
48066
US

COPPER&BR		110731616		4076		INCLUSION		Serial:20190205-0110731616		Pg 2of2																					
CUSTOMER PURCHASE ORDER NO. & ITEM 5400424165-R01						Constellium ORDER NO. 264848			CERTIFICATION "Constellium Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Constellium Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination." Constellium Rolled Products Ravenswood, LLC 859 Century Road P.O. BOX 88 RAVENSWOOD, WV 26164 USA  Dave Dunberger - Laboratory Manager																						
ALLOY 7075	GLAD	TEMPER T651	GAUGE 2.63000 in 64.26 mm	WIDTH 60.50000 in 1.537 mm	LENGTH 144.50000 in 3.670 mm																										
ITEM ORDERED SPEC PLATE, SAWED MILL FINISH																															
CUSTOMER SPECIFICATION AMS QQ-A-250/12A																															
PART NUMBER ALFLR01004			B/L NUMBER 112706		DATE SHIPPED 02/05/2019																										
WT. SHIPPED 7020.000 LB		NO. OF PIECES 000003		GOVT. CONTRACT NO.																											
Chemistry (Actual): <table border="1"> <thead> <tr> <th></th> <th>SI</th> <th>FE</th> <th>CU</th> <th>MN</th> <th>MG</th> <th>CR</th> <th>ZN</th> <th>TI</th> <th>ZR</th> </tr> </thead> <tbody> <tr> <td>Core</td> <td>0.07</td> <td>0.17</td> <td>1.42</td> <td>0.04</td> <td>2.50</td> <td>0.20</td> <td>5.64</td> <td>0.04</td> <td>0.01</td> </tr> </tbody> </table>													SI	FE	CU	MN	MG	CR	ZN	TI	ZR	Core	0.07	0.17	1.42	0.04	2.50	0.20	5.64	0.04	0.01
	SI	FE	CU	MN	MG	CR	ZN	TI	ZR																						
Core	0.07	0.17	1.42	0.04	2.50	0.20	5.64	0.04	0.01																						
OTHERS-EACH: .05 MAX OTHERS TOTAL: .15 MAX AL REMAINDER																															
All material contained in this lot was cast and manufactured in the USA																															
QUALITY TEXTS: Constellium Rolled Products Ravenswood, LLC (Constellium) certifies that all metals and materials supplied are in compliance with European Union Directives 2002/95/EC and 2011/65/EU. Constellium further certifies that a copy of these directives, which provides restrictions on the use of certain hazardous substances (RoHS) in electrical and electronic equipment, have been received and read in their entirety. Constellium understand and agrees, as a supplier that it is responsible for meeting the requirements of the RoHS and RoHS2 directives.																															
THIS TEST REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF THE LABORATORY OR AUTHORIZED QUALITY DELEGATE. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. CHEMISTRY BY OES: ARKSPARK CHEMISTRIES REPORTED IN PERCENTAGE BY WEIGHT WHEN FRACTURE TOUGHNESS TEST REQUIRED, TESTED PER ASTM E399 WHEN TENSILE TEST REQUIRED, TESTED PER ASTM E8: B557 DUNS Number: 090570149; CAGE Code: 1YW19 Mercury is not a normal contaminant in aluminum alloys and neither mercury nor any of its compounds were utilized in the manufacture of our product. "END OF CERTIFICATION"																															
P-860-155D REVISED: 01 2018																															

From: TK Materials CA, Ltd.

Cust. WEJAY MACHINE PRODUCTS CO LTD Del.: 2406829910

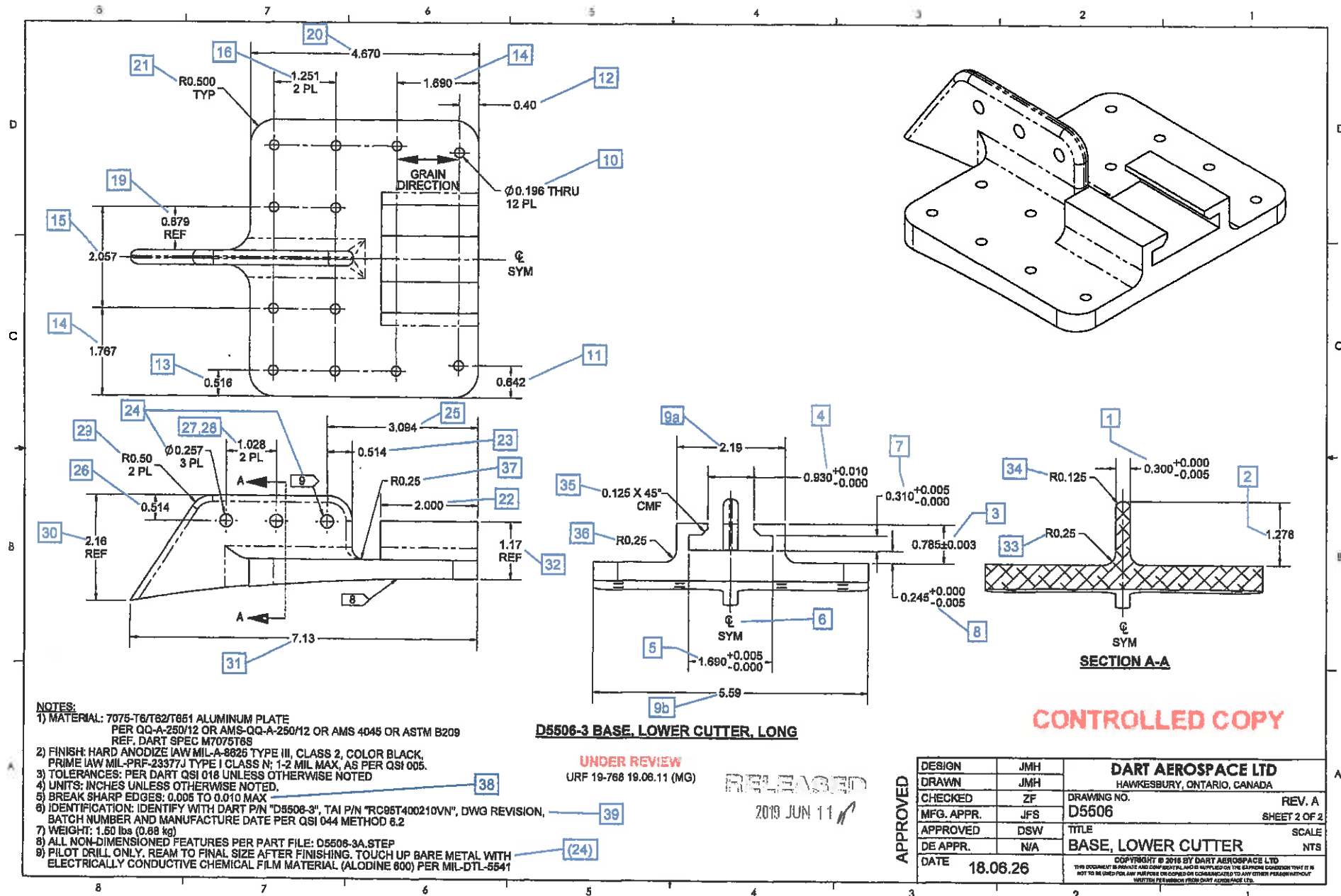
CstAr

CstOr 35073

Wgt.: 36.196 LB

Date 06/20/2019

Thomas Savitzky





Customer DART Aerospace Customer P.O. POHB043778 item 4
 Drawing # D5506 Drawing rev A
 Part Number D5506-3P E.C.O. -
 Part Name Base, Lower Cutter Material Alum. Plate 7075-T651
 Serial # 39579-4-001 Inspected by Cliff Smith
 Job # 39579 Signature:



Comment: Final Dim. Insp. -1st Article



Overall Result

All Characteristics: 72
 Out of tolerance: 0
 Over Warning Limit: 0
 Not Calculated: 0

Feature	ID	Actual	Nominal	Pos Tol.	Neg Tol.	Deviation	<- >
1 2_B1	CartDist	0.2983	0.3000	0.0000	-0.0050	-0.0017	
Parallelism rel .300 dim	GDT Par	0.0021	0.0000	0.0025		0.0021	
2 2_B1	Z	1.2761	1.2780	0.0100	-0.0100	-0.0019	
3a 2_B3	Z	0.7857	0.7850	0.0030	-0.0030	0.0007	
3b 2_B3	Z	0.7856	0.7850	0.0030	-0.0030	0.0006	
4 2_B3	CartDist	0.9333	0.9300	0.0100	0.0000	0.0033	
5t 2_A6	CartDist	1.6911	1.6900	0.0050	0.0000	0.0011	
5m 2_A4	CartDist	1.6916	1.6900	0.0050	0.0000	0.0016	
5b 2_A5	CartDist	1.6920	1.6900	0.0050	0.0000	0.0020	
6a 2_B4	GDT Sym	0.0008	0.0000	0.0050		0.0008	
6b 2_B4	GDT Sym	0.0001	0.0000	0.0050		0.0001	
7a 2_B3	CartDist	0.3117	0.3100	0.0050	0.0000	0.0017	
7b 2_B3	CartDist	0.3124	0.3100	0.0050	0.0000	0.0024	
8a 2_C4	Z	0.2427	0.2450	0.0000	-0.0050	-0.0023	
8b 2_C5	Z	0.2426	0.2450	0.0000	-0.0050	-0.0024	
9a 2_C4	CartDist	2.1896	2.1900	0.0300	-0.0300	-0.0004	
9b 2_A4	CartDist	5.5873	5.5900	0.0300	-0.0300	-0.0027	
10a 2_D5(1)	D	0.1978	0.1960	0.0050	-0.0010	0.0018	
10a 2_D5(2)	D	0.1981	0.1960	0.0050	-0.0010	0.0021	
10b 2_D5(1)	D	0.1982	0.1960	0.0050	-0.0010	0.0022	
10b 2_D5(2)	D	0.1980	0.1960	0.0050	-0.0010	0.0020	
10b 2_D5(3)	D	0.1980	0.1960	0.0050	-0.0010	0.0020	
10b 2_D5(4)	D	0.1978	0.1960	0.0050	-0.0010	0.0018	
10b 2_D5(5)	D	0.1977	0.1960	0.0050	-0.0010	0.0017	
10b 2_D5(6)	D	0.1979	0.1960	0.0050	-0.0010	0.0019	
10c 2_D5(1)	D	0.1978	0.1960	0.0050	-0.0010	0.0018	
10c 2_D5(2)	D	0.1978	0.1960	0.0050	-0.0010	0.0018	
10c 2_D5(3)	D	0.1980	0.1960	0.0050	-0.0010	0.0020	
10c 2_D5(4)	D	0.1980	0.1960	0.0050	-0.0010	0.0020	
11-12 2_C6,D6(1)	GDT Po2d	0.0039	0.0000	0.0200		0.0039	
	X	-0.3985	-0.4000			0.0015	
	Y	0.6407	0.6420			-0.0013	



Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-->
11-12 2_C6,D6(2)	GDT Po2d	0.0033	0.0000	0.0200		0.0033	└
	X	-0.3988	-0.4000			0.0012	
	Y	4.9468	4.9480			-0.0012	
13-16 2_C7,D6(1)	GDT Po2d	0.0033	0.0000	0.0200		0.0033	└
	X	-1.6898	-1.6900			0.0002	
	Y	0.5176	0.5160			0.0016	
13-16 2_C7,D6(2)	GDT Po2d	0.0008	0.0000	0.0200		0.0008	└
	X	-2.9409	-2.9410			0.0001	
	Y	0.5164	0.5160			0.0004	
13-16 2_C7,D6(3)	GDT Po2d	0.0033	0.0000	0.0200		0.0033	└
	X	-4.1913	-4.1920			0.0007	
	Y	0.5145	0.5160			-0.0015	
13-16 2_C7,D6(4)	GDT Po2d	0.0089	0.0000	0.0200		0.0089	└
	X	-1.6901	-1.6900			-0.0001	
	Y	5.0696	5.0740			-0.0044	
13-16 2_C7,D6(5)	GDT Po2d	0.0063	0.0000	0.0200		0.0063	└
	X	-2.9413	-2.9410			-0.0003	
	Y	5.0709	5.0740			-0.0031	
13-16 2_C7,D6(6)	GDT Po2d	0.0023	0.0000	0.0200		0.0023	└
	X	-4.1919	-4.1920			0.0001	
	Y	5.0729	5.0740			-0.0011	
14-16 2_C8,D7(1)	GDT Po2d	0.0007	0.0000	0.0200		0.0007	└
	X	-2.9407	-2.9410			0.0003	
	Y	1.7668	1.7670			-0.0002	
14-16 2_C8,D7(2)	GDT Po2d	0.0039	0.0000	0.0200		0.0039	└
	X	-4.1914	-4.1920			0.0006	
	Y	1.7651	1.7670			-0.0019	
14-16 2_C8,D7(3)	GDT Po2d	0.0069	0.0000	0.0200		0.0069	└
	X	-2.9409	-2.9410			0.0001	
	Y	3.8206	3.8240			-0.0034	
14-16 2_C8,D7(4)	GDT Po2d	0.0034	0.0000	0.0200		0.0034	└
	X	-4.1916	-4.1920			0.0004	
	Y	3.8223	3.8240			-0.0017	
19a 2_D8	CartDist	0.8773	0.8790	0.0100	-0.0100	-0.0017	└
19b 2_D8	CartDist	0.8794	0.8790	0.0100	-0.0100	0.0004	└
20a 2_D6	X	-4.6680	-4.6700	0.0100	-0.0100	0.0020	└
20b 2_D6	X	-4.6678	-4.6700	0.0100	-0.0100	0.0022	└
21 2_D7	R	0.4992	0.5000	0.0100	-0.0100	-0.0008	└
22 2_B6	X	-2.0026	-2.0000	0.0100	-0.0100	-0.0026	└
23 2_B7	CartDist	0.5138	0.5140	0.0100	-0.0100	-0.0002	└
24 -per note 9- 2_B7(1)	D	0.2437	0.2420	0.0060	-0.0010	0.0017	└
24 -per note 9- 2_B7(2)	D	0.2436	0.2420	0.0060	-0.0010	0.0016	└
24 -per note 9- 2_B7(3)	D	0.2433	0.2420	0.0060	-0.0010	0.0013	└
25-28 2_B6,B7(1)	GDT Po2d	0.0064	0.0000	0.0200		0.0064	└
	Z	-0.5171	-0.5140			-0.0031	
	X	-3.0931	-3.0940			0.0009	
25-28 2_B6,B7(2)	GDT Po2d	0.0063	0.0000	0.0200		0.0063	└
	Z	-0.5170	-0.5140			-0.0030	
	X	-4.1211	-4.1220			0.0009	
25-28 2_B6,B7(3)	GDT Po2d	0.0061	0.0000	0.0200		0.0061	└
	Z	-0.5169	-0.5140			-0.0029	
	X	-5.1492	-5.1500			0.0008	
33.5 angle from e-model	A2	-33.4320	-33.5000	0.5000	-0.5000	0.0680	└



Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<- ->
29a 2_B8	R	0.5061	0.5000	0.0300	-0.0300	0.0061	-
29b 2_B8	R	0.5106	0.5000	0.0300	-0.0300	0.0106	-
30 2_B8	Z	-2.1538	-2.1600	0.0300	-0.0300	0.0062	-
31 2_B7	X	-7.1190	-7.1300	0.0300	-0.0300	0.0110	-
32 2_B5	Z	-1.1695	-1.1700	0.0300	-0.0300	0.0005	-
Mount Face_Point 1_e-mode	Z	-0.7463	-0.7491	0.0100	-0.0100	0.0028	-
Mount Face_Point 2_e-mode	Z	-0.6068	-0.6095	0.0100	-0.0100	0.0027	-
Mount Face_Point 3_e-mode	Z	-0.5264	-0.5277	0.0100	-0.0100	0.0012	-
Mount Face_Point 4_e-mode	Z	-0.4132	-0.4137	0.0100	-0.0100	0.0005	-
Mount Face_Point 5_e-mode	Z	-0.3837	-0.3827	0.0100	-0.0100	-0.0010	-
Mount Face_Point 6_e-mode	Z	-0.3838	-0.3827	0.0100	-0.0100	-0.0011	-
Mount Face_Point 7_e-mode	Z	-0.4151	-0.4164	0.0100	-0.0100	0.0013	-
Mount Face_Point 8_e-mode	Z	-0.5281	-0.5305	0.0100	-0.0100	0.0024	-

Manually Inspected Details

33 2_B2 R0.25
 34 2_B2 R0.125
 35 2_B5 0.125 x 45 chamfer
 36 2_B5 R0.25
 37 2_B6 R0.25
 38 2_A8 Deburring per note 5
 39 2_A8 Identification per note 6

R.250
R.125-130
-127-130x45°
R.250
R.250
PASSED
PASSED



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044008



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044008

PO Date: 7/15/19

Due Date: 7/19/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments: ***RUSH***

E-MAILED
2019-07-19

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196015	646.2910	Deflector : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Anodize, Color Black / Prime As per Dwg 646.2900 Rev. N/C	Firmed -		7/19/19	16 pcs	0 pcs	16 pcs	\$53.77/pcs	\$860.32
2	196673	D5500-1	Body, Upper Cutter Issue P/O to ATG: HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** Certification of Conformity is required	Firmed -		7/19/19	3 pcs	0 pcs	3 pcs	\$26.52/pcs	\$79.56
3	196674	D5501-1	Body, Lower Cutter, Long Issue P/O to ATG: HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** Certification of Conformity is required	Firmed -		7/19/19	2 pcs	0 pcs	2 pcs	\$26.52/pcs	\$53.04



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044008



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	196675	D5505-1	Base, Upper Cutter Outsource process-Anodize per QSI017 4.1.10.1 - Issue P/O to ATG: HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL-P- 23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** Certification of Conformity is required	Firmed	-	7/19/19	3 pcs	0 pcs	3 pcs	\$24.62/pcs	\$73.86
				X3			JUL 19 2019				DP
							5197502				
5	196676	D5506-3	Base, Lower Cutter, Long Issue P/O to ATG: HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** Certification of Conformity is required	Firmed	-	7/19/19	2 pcs	0 pcs	2 pcs	\$24.62/pcs	\$49.24
				X2			5197504				DP
											MDAS 61 9989
Grand Total:										\$1,116.02	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/19/19 8:32 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918248

Date: 18-Jul-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 3 ea	Part: D5500-1 ✓ Body, Upper Cutter Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 25476 PO: POHB044008 ✓ Rev: A8 Line: 2		
✓ 2 ea	Part: D5501-1 ✓ Body, Lower Cutter, Long Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 25477 PO: POHB044008 ✓ Rev: A7 Line: 3		
✓ 3 ea	Part: D5505-1 ✓ Base, Upper Cutter Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 25478 PO: POHB044008 ✓ Rev: A Line: 4		
✓ 2 ea	Part: D5506-3 ✓ Base, Lower Cutter Long Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), Rev: A Line: 5		

RECEIVED

JUL 18 2019

DART AEROSPACE LTD.

DAS 61 9-89

Made in Canada.

RECEIVED

JUL 18 2019

DAS
61
9-89

DART AEROSPACE LTD.

Made in Canada.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918248

Date: 18-Jul-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	.0006-.0009" (6 - .9 mils) per drawing. Job: 25479 PO: POHB044008 ✓	Line: 5	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>JUL 18 2019</u> Certified Signature: <u></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

Entered: JK Date: Oct 21/19



NCR No. 19-7425 WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>196676</u> Part No. <u>D5506-3</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☒					
Date: <u>JUL 12 2019</u>		Sequence #: <u>140</u>		QTY Affected: <u>2 of 2</u>			MRB (QSI042) INSP <u>12</u> <u>19/10/27</u>		
Description Work Order Deviation <u>Ø0.257 holes are too small Ø0.243</u>				Disposition <u>drill hole at Ø.257</u>				Completed By <u>DAS</u> <u>40</u> <u>JUL 12 2019</u> Lead hand / Supervisor <u>19/07/26</u> QC / QA Coordinator <u>DAS</u> <u>68</u> <u>9-63</u> <u>OCT 11 2019</u>	
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☒ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread							
		Other/Details:							